

Work Order ID 131211

March-30-15 1:34:58 PM

Shop 3/1/03

131211

Page 1

Item ID: D4799-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Clamp

Start Date: 3/30/15 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/31/15 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

u

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4799

C

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg

Dwg Rev: *C*

Prog Rev: *C*

2-Deburr if necessary

4 *0* *Jm15-330*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

4 *0* *Jm15-330*

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Page 2

Item ID: D4799-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clamp

Start Date: 3/30/15

Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/31/15

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
38
9-89

MAR 31 2015

130

Form as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

DAS
30
9-89

15/03/31

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

DAS
38
9-89

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Item ID: D4799-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 3/30/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 3/31/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

4 MAR 31 2015 DAS 6 3-89

MCS 15-03-31

U 15-03-31

Picklist Print

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Page 1

Work Order ID: 131211

131211

Parent Item: D4799-1

D4799-1

Parent Item Name: Clamp

Start Date: 3/30/15

Required Date: 3/31/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 13-03-28 JLM VERIFIED BY:DD IPP
REV:B AS PER REV C JLM 15.03.30 VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased	No				sf	170.0000		1			
M304S14GA										**		Jm 15-3-30	
304SS sheet .080													

Location

Loc Qty

Loc Code

MAT019

170

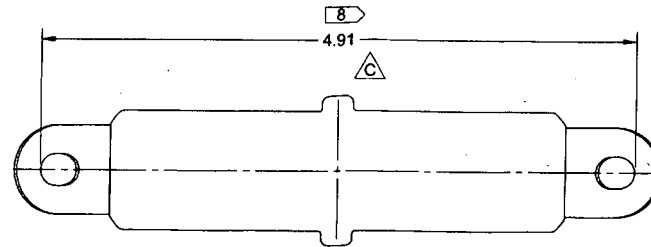
M126075

48

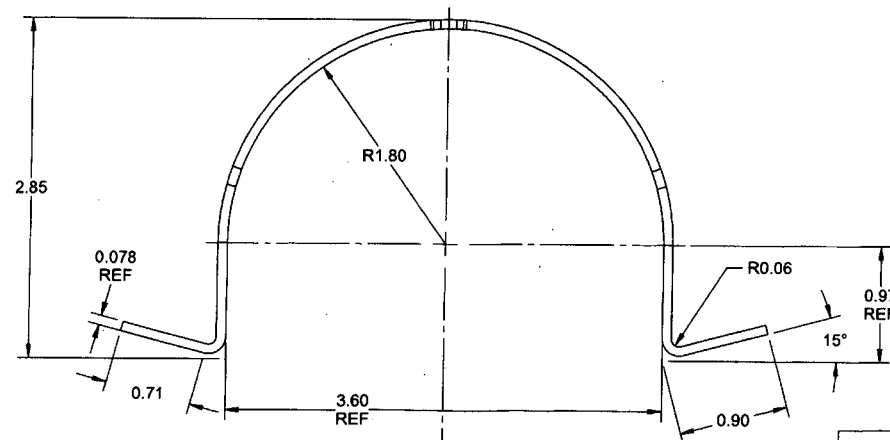
M129972

122

126075



Wb 131211



D4799-1 CLAMP



NOTES:

- 1) MATERIAL: MAKE FROM D4799-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs
- 8) DIMENSIONED FROM BOTTOM SURFACE OF CLAMP
- 9) NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D4799-1F-RevC.DXF"

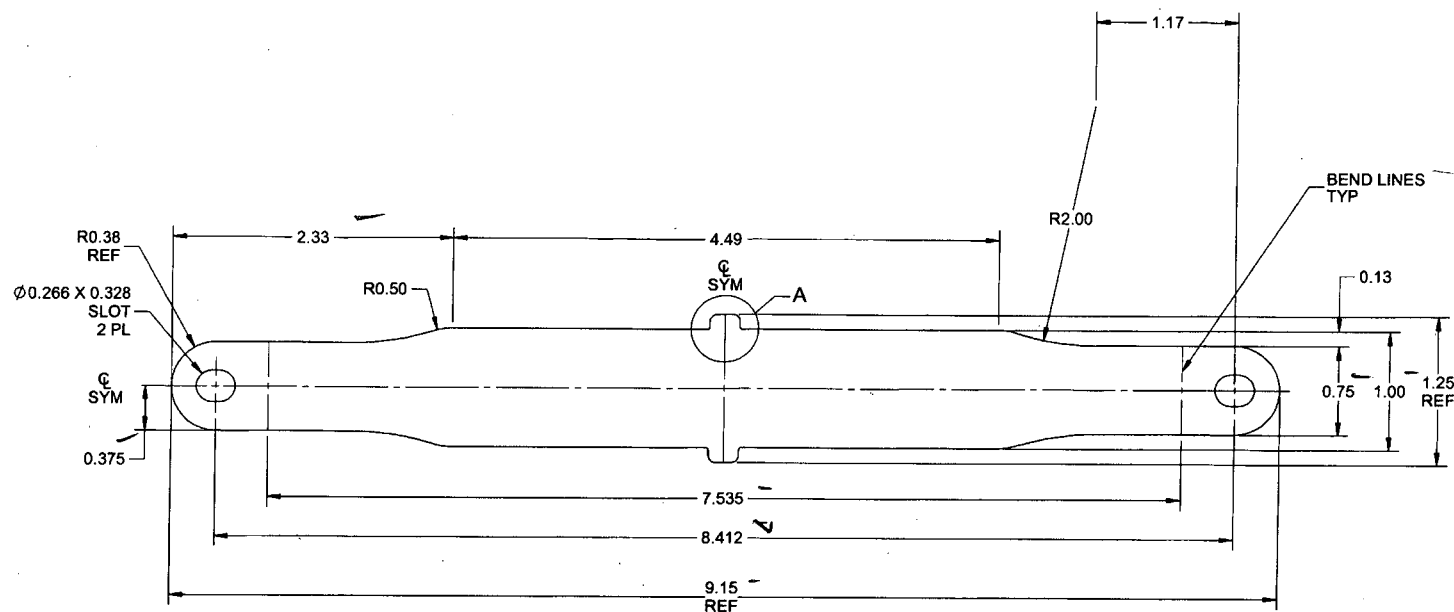
RELEASED

2015 MAR 30
A.P. EGN 15-535

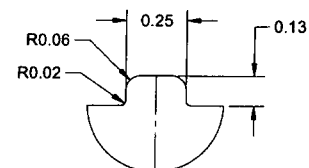
C	ADD CUSHION RETENTION FEATURES, REPLACE HOLES WITH SLOTS, 2.85 WAS 2.80, REASON PAR 14-331, NCR 14-3521; ZND5-1, A5-1, A8-1, B6-2, B2-2	VS	14.10.01
B	DECREASE LENGTH FROM 9.53 TO 9.16, ZN CS-1	DC	13.05.07
A	NEW ISSUE	DC	13.03.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4799 TITLE CLAMP SCALE NTS	
DRAWN	VS		
CHECKED	RF		
MFG. APPR.	DD		
APPROVED	HS		
DE APPR.	DS		
DATE	14.10.01		

APPROVED

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D4799-1F CLAMP FLAT PATTERN



DETAIL A

RELEASED

2015 MAR 30
A.P. ECN 15-535

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET
ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316)
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.02 lbs
 - 8) NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D4799-1F-RevC.DXF"

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4799	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CLAMP	NTS
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